

142186

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N900040100

Setup Start *NS1*

Stop *NS2*

16

Cust Item ID:

16

Customer:

DAS

Date: MAR 02 2016

Tooling:**Date:**

Run Start *NR1*

QC: _____

Date: _____ **SPC (Y/N):** _____

Date:

Stop *NR2*

[illegible]

DQA: 1 Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :				
Misidentified ☐	Past Due ☐					

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Wednesday, March 02, 2016 7:55:34 AM

Item ID: D3001-1 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Doubler
Start Date: 3/10/2016 Start Qty: 16.00 *16* Cust Item ID:
Required Date: 3/10/2016 Req'd Qty: 16.00 *16* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				(16)			DAS 38 9-89 MAR 03 2016
130 *130* Small Fab Small Fab	Small Fab Memo 1-Scuff surfaces with 80grit sandpaper per QSI 006 2-Deburr.	0.00 0.02				16x			DAS 38 9-89 16/03/03 DAS 36 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				(16)			DAS 38 9-89 MAR 03 2016

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Wednesday, March 02, 2016 7:55:34 AM

Item ID: D3001-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Doubler
Start Date: 3/10/2016 Start Qty: 16.00 *16* Cust Item ID:
Required Date: 3/10/2016 Req'd Qty: 16.00 *16* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00						16-3-3 16	
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00						16	38 9-89 MAR 03 2016
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>57483</u> <u>GA02</u> Memo	0.00 0.00						16 DAS 6 9-89	MAR 04 2016

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Wednesday, March 02, 2016 7:55:34 AM

Item ID: D3001-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 3/10/2016 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 3/10/2016 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.03							
Quality Control									

MCS ~~MAR 07 2016~~

MCS MAR 07 2016

Picklist Print

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Work Order ID: 142186

142186

Parent Item: D3001-1

D3001-1

Parent Item Name: Doubler

Start Date: 3/10/2016

Required Date: 3/10/2016

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP A01.03.22New IssueEC

IPP rev.B added scuffing NCR 061 EC

IPP Rev:C Now On Waterjet 07-12-13 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040

Purchased

No

100

sf

66.9669

0.7083

11.92926

M5052H32S 040

**

02/16/03/02

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT023

66.9669262

m129530

4.0984

m132546

6.1685262

m133550

24.7

m1342217

32

12

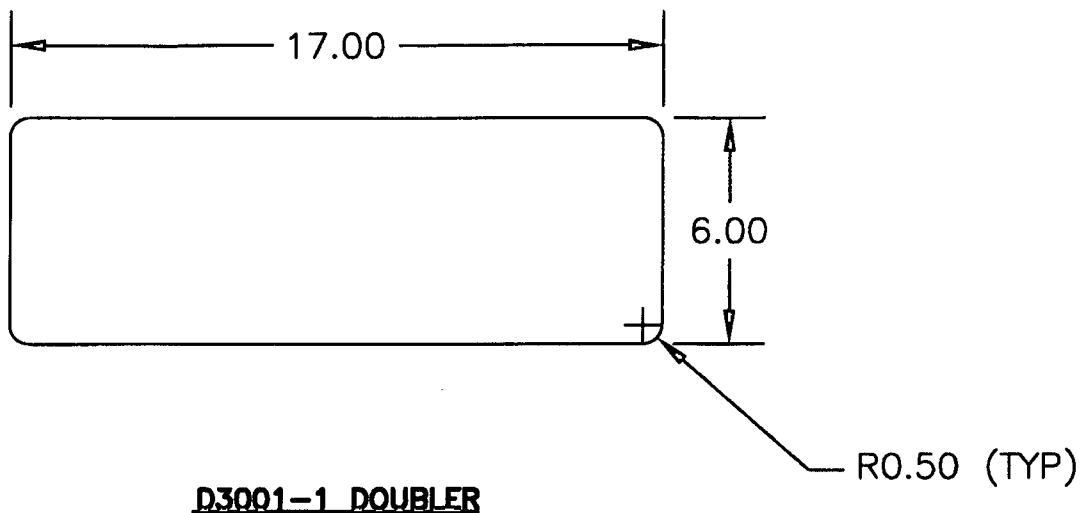


RELEASE
6.11.13

MAR 02 2016

DAS
13
9-89

W 10.14 2184



D3001-1 DOUBLER

DESIGN	DRAWN BY	DART AEROSPACE LTD
90	CB	HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
YJH	[Signature]	D3001
DATE		TITLE
06.10.06		DOUBLER
A	01.03.21	NEW ISSUE
B	06.10.06	ADD BONDING PREP NOTE
		SCALE
		1:5
		SHEET 1 OF 1
		REV. B

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32/H34 SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.040)
OR ALUMINUM 6061-T6 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) PREPARE FOR BONDING TO COMPOSITE STRUCTURE
PER DART QSI 006 4.10
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS TO 0.010 MAX

